

Date: Wednesday, 3/28/2007 12:40:05 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTER FWD SADDLE
Job Number	: 31528		
Estimate Number	: 11076		
P.O. Number	: N/A	Part Number	: D5951
This Issue	: 3/28/2007 S.O. No. : N/A	Drawing Number	: D5951 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 28079	Material	: N/A
Written By	:	Due Date	: 4/15/2007 Qty: 6 Um: Each
Checked & Approved By	: <u>07.03.28</u>		
Comment	: Est Rev:E Re-Format 05-11-29 JLM		
	: Est Rev:E Re-Format 05-11-29 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

N 10' D6101013 Saddle billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
D6101-013 (7075-T7351)
Size 2.50" x 10.10" X 8.25" (Grain along 10.10")
Batch: B25356

J.F. 07/03/29

2.0 HAAS3 HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5951, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

J.L/J.F. 07/03/30

3.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.L/J.F. 07/03/30

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.M. 07/04/01

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Fd

07/04/02 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PP Date: 07/09/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/28/2007 12:40:05 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 31528

Part Number: D5951

Job Number:



Seq. #

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m 103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07/04/02 (6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/4/03 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/4/03 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

Job Completion



07-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31528
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.437	0.444		0.439"	.440	.440	.440		
B	1.745	1.755		1.749"	1.750	1.750	1.750		
C	5.245	5.255		5.247"	5.251	5.251	5.250		
D	6.995	7.005		6.995"	7.000	6.998	6.997		
E	5.745	5.755		5.748"	5.748	5.750	5.751		
F	4.745	4.755		4.749"	4.750	4.750	4.750		
G	0.312	0.319		0.315"	.316	.316	.316		
H	1.522	1.532		1.529"	1.526	1.527	1.526		
I	3.048	3.058		3.056"	3.053	3.054	3.054		
J	4.575	4.585		4.580"	4.579	4.580	4.580		
K	0.312	0.319		0.314"	.316	.316	.316		
L	0.495	0.505		.500"	.500	.499	.498		
M	0.490	0.510		.496"	.495	.505	.494		
N	1.615	1.635		1.625"	1.625	1.625	1.625		
O	7.990	8.010		8.006"	7.998	7.998	7.998		
P	2.240	2.260		2.250"	2.250	2.254	2.246		
Q	0.307	0.312		0.312"	.310	.310	.312		
R	0.760	0.765		.760"	.761	.761	.761		
S	0.490	0.510		.500"	.501	.496	.499		
T	1.375	1.395		1.381"	1.382	1.384	1.396		
U	2.000	2.020		2.000"	2.002	2.003	2.012		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F.
Date:	07/03/30 / 07/03/31

Audited by:	cmk
Date:	07/04/01

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	EF

DART AEROSPACE LTD		Work Order:	31528
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
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B	1.745	1.755		1.750	1.749				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		6.998	6.998				
E	5.745	5.755		5.751	5.750				
F	4.745	4.755		4.750	4.750				
G	0.312	0.319		.316	.316				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.054	3.053				
J	4.575	4.585		4.579	4.580				
K	0.312	0.319		.316	.316				
L	0.495	0.505		.498	.499				
M	0.490	0.510		.509	.508				
N	1.615	1.635		1.625	1.625				
O	7.990	8.010		7.998	7.998				
P	2.240	2.260		2.258	2.257				
Q	0.307	0.312		.310	.310				
R	0.760	0.765		.761	.761				
S	0.490	0.510		.500	.499				
T	1.375	1.395		1.382	1.382				
U	2.000	2.020		2.002	2.002				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L
Date:	07/03/31

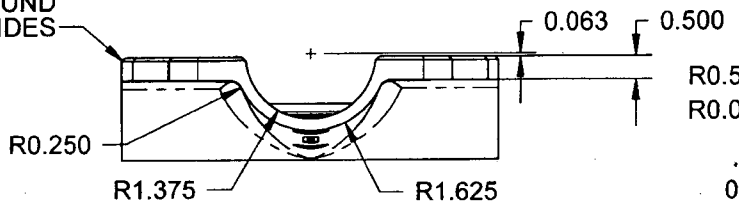
Audited by:	mv
Date:	07/04/01

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	EF

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5951	REV. B SHEET 1 OF 1
DATE 06.11.07		TITLE OUTER FWD SADDLE	SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;	

CHAMFER
0.075 X 45°
ALL AROUND
BOTH SIDES



ENGRAVE PART NO.
AND BATCH NO.
WITH MIN RAD OF
0.010 TO MAX
DEPTH OF 0.010

R0.500
 $\phi 0.316$
(8 PLACES)

DRILL $\phi 0.316$ THRU
 $\phi 0.750$ SPOT FACE
(2 PLACES)

GRAIN
DIRECTION

ENGRAVE DART LOGO WITH
MIN RAD OF 0.250 TO MAX
DEPTH OF 0.015

R0.660
 $\phi 0.438$
(4 PLACES)

VIEW A-A

0.500

1.750

5.250

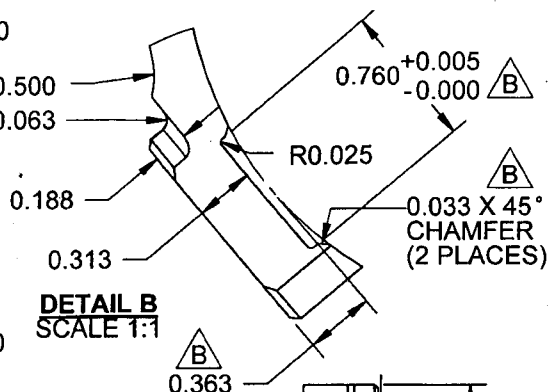
7.000

8.000

0.040 X 45° CHAMFER
ALL AROUND

NOTES:

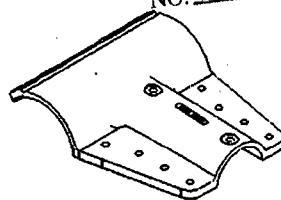
- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



DETAIL B
SCALE 1:1

D5951 OUTER FWD SADDLE

WORK ORDER
NO. **31528**



ISOMETRIC VIEW
SCALE 1:8

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